Work Orde November-27-12		03		*9	380).3*						Page 1
Revision ID:	41232-000-001 Emergency Flota	-002 ation Step Actuator, R	Н	Accept		*N900	<u> </u>	100) * s	Setup Start Stop	*N *N	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*			Cust Item Customer:						
Approvals:	Process Plan:	Mr2	Date: \72-11- Z				Date:		A	Run Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hou	ırs	Tool ID	Tool #	Plan Code	Accept Qty		Reject Number	Insp. Stamp
Draw Nbr	Revisi	ion Nbr				·	-				1	
41232-000-001	Rev A		4.6		DAS 27						1	
*1 \\ \O \\ \C \\ \Document Control	Γ	Memo Photocopy b	iluefile D412-763 & type I	0.00 0.00 abels per PPP4123:	B 9	р сна	· · · · · · ·			4	N BX	5 13-9-9
*110 *110*	P	Pick Kit		0.00					,			337
Packaging Packaging		Мето		0.00	DAS 27 9-89				\			
*120	C	QC4- 100% Inspect kits	for completeness	0.00		10)			i
QC Quality Control		Memo		0.00								

			DQA:	Date:	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		

										QA Closed:	Date	<u>:</u>	
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	o				Rework Scrap Use-as-is Work Order Update	The	Skid-t Machi ermoforn Large	ning	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update	Initia		Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng	Desc	ription	Date	Verification	QC _i Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process													
Supplier Training Unapproved	-		:										
					F/	AULT CA	TEGORY						
Landin	g Gear				General			_		_			
-	Bending Centre No Cracks Crushed/6			D/S	Bend BOM/Route Broken/Damaged Burrs	Inspi	in Iware ection Inci ructions In		/Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct _	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
	Cuffs	——————————————————————————————————————				Mai	Maintenance Mislabeled			Part Moved Positioned Wrong			
	Inspection	n Strip in	Tube		Cut Too Short	Misr	ead			Power Loss/	Surge	Other	
	Ripples in	Bend	d Drill Holes					Offset					
	Torque Waves in Extrusion Drawing O					Out	of Calibra	tion					
Ī	Turning Sequence Finish					Out of Sequence							
						Outside Dimensions							

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Work Orde				*938	303*					Page 2
Item ID: Revision ID: Item Name:	41232-000-0	001-002	н	Accept	*N900	<u>04</u> 0	100)*	Setup Start	18.71
Start Date: Required Date: Reference:	11/22/12 12/14/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:				i
Approvals:	Process Pla	an:	Date:	Tooling:	Da	te:			Run Start	"INK!"
	QC:	··	Date:	SPC (Y/N):	Da	te:			Stop	*NR2*
Sequence ID/ Work Center II	D	Operation Description Packaging	<u> </u>	Set Up/ Run Hours 0.00	Tool JD	Tool #	Pian Code	Accep Qty	t Reject Qty	Reject Insp. Number Stamp
130 Packaging Packaging		Memo ,	pack for shipping as per	0.00 PPP 41232-000-001-002					<u>a</u>	13-9-10
140 *140*		QC21- Final Inspection	Work Order Release	0.00			1		13/9	111
QC Quality Control		Memo		0.00					·	

h 13.09.11

				DQA:	Date:	
ICR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Dat	te:
Work Ord	ler:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	[Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	n QC Inspector
Doc/Data]										
Equip/Tooling													
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ļ .					-		AULT	CATE	GORY				
Landi		l .				General		• .			1	ſ	Pressure/Forced
,	-	Bending			,	Bend	├ ──	ārain		<u></u>	Ovalized	.	Temperature/Cure
	-	Centre N	ot Concer	ntric to (⁻ //5	BOM/Route	\vdash	lardwa			Over/Under Part Incorre		Weld
	Cracks Broken/Dama							•	ion Incomplete ions Incomplete/	Unclose	Part Lost/M		Wrong Stock Pulled
	Crushed/Crimped. Burrs Cuffs Contamination						—∹		nance	Officieal	Part Moved	- 1	
		Heat Trea	at		-	Countersink	-	viaiiike Viislabe		 -	Positioned \		
	\vdash	Inspectio		Tuha	 	Cut Too Short	 	viisiaue Viisread		 -	Power Loss,	· ·	Other
	${f H}$	Ripples in	•	IUNE	-	Drill Holes	\vdash	offset	•	<u> </u>]. 🕶 (Sui Bc	L
	-	Torque V		xtrusio	, ├	Drawing	Щ.		Calibration				
	H	•	Sequence			Finish	-		Sequence				
ĺ	H	Wave/Tw			}-	Folio	-		Dimensions				·

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Picklist Print

November-27-12 11:25:14 AM

Work Order ID:

93803

Parent Item:

41232-000-001-002

Parent Item Name:

Emergency Flotation Step Actuator, RH

Start Date: 11/22/12

Required Date: 12/14/12

Page 1

Start Qty: 1.00

Required Qty: 1.00 +

Comments:

IPP Rev:A New Issue 07-02-28 JLM

	006-001 replace wi	th D4094-1 DD ve	rf:EC										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq 1D	Unit of Measur		Qty per Kit	Total Qty	Qty Issued	Date Issued	·Status
Hose ass y-Step Actuator	DAS	Purchased	No			110	Each	4.0000	(-	1	745 33 800		7
	27 9-89			Location		Loc Qty	j	Loc Code			ייםר	100	
	2			ST389	1005	4			<u> </u>	1005			
41232-200-001-002 Step Actuator RH Ass'y		Manufactured	No	12	1005	110	Each	2.0000	1 1 ×	2005	33		82
,				Location ST377		Loc Oty 2	1	Loc Code	10	1486	La Ca		
41232-200-003-001 Spring (Step Actuator)		Manufactured	No	88	172	110	Each	88.0000	(1)	1	33	, پیر	2
	540			Location		Loc Oty	4	Loc Code			2 30	V	Sie Control of the Co
	DAS 27			FG		4							
	9-89			54 ST377	173	4 84							
		1 √			173	84			15	4173			:
41232-200-004-001 Reducer Tee Assembly		Manufactured	No			110	Each	4.0000		1	94s 33	·	4
				Location		Loc Otv		Loc Code			•	E	
DAS 27				ST377		4			·-·				
3-8					077 106	1			48	7106			
41232-200-005-001 Spacer (Step Actuator)		Manufactured	No	67	100	110	Each	2.0000	3) 9	3808	<u>04</u> ,		<u>3-09-06</u>
DAS				<u>Location</u>		Loc Qty	<u> </u>	Loc Code			4		
27 				ST378		2			a.			V	
3-00				86	078	2				⊕078			ı

IPP Rev:B 10.06.11 41232-200-

				DQA:
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE	

NCK. 1	es ,	/ 140				WORK ORDER NOIS-	CONFO	/INIV	MARCE / OPE		QA Closed:	Date:	
Work Orde	:r: _					DISPOSITION				AGAINST DEI	PARTMENT	/PROCESS	
Part N	lo					Rework Scrap Use-as-is		N	Skid-tube Machining oforming	Crosstube Small Fab Finishing		Water Jet 3 d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo					Work Order Update] '"		Large Fab	Composite	Recystor	Supplier	J Other
Root					Descri	ption of work order update	Initia	al	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief E	ng	Descr	ription	Date	Verification	QC Inspector
Doc/Data	4												
quip/Tooling	4												
Operator							İ						
Material	_											ŧ	
Setup	_												
Other	_						ļ	- [
Process													
Supplier	_										•		
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							AULT CA	ATEG	ORY	-			
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	_	ending				Bend	Gra			<u> </u>	Ovalized		Pressure/Forced
-	_	entre No	t Concer	itric to (^{D/S} _	BOM/Route	\vdash	dwar			Over/Under	├	Temperature/Cure
		racks			<u> </u>	Broken/Damaged	-		on Incomplete		Part Incorre	⊢	Weld
	_	rushed/C	rimped.		<u> </u>	Burrs	\vdash		ons Incomplete/U	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
}		uffs			<u> </u>	Contamination			nance	<u> </u>	Part Moved	·	
1	_	eat Treat			<u> </u>	Countersink	⊢	label	ed	<u> </u>	Positioned V		⊣
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·	—1	ipples in				Drill Holes	Offs					<u> </u>	
Ţ	⊸;	orque Wa		xtrusio	` <u> </u>	Drawing	\vdash		alibration				
Ļ	_	urning Se				Finish			equence			·	
	_lv	Vave/Twi	st in Tub	е		Folio	Outs	side I	Dimensions				

Date:

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November-27-12 11:25:14 AM

Work Order ID:

93803

Parent Item:

41232-000-001-002

Parent Item Name:

Emergency Flotation Step Actuator, RH

Start Date: 11/22/12

Required Date: 12/14/12

Start Qty: 1.00

Required Qty: 1.00

Parent Item Name:	Emergency Flotation Step Actuator, I	KH				Sta	rt Qty: 1.00	Required Qty: 1.00
AN4-23A Bolt	Purchased	No		110	Each	935.0000	<u> </u>) / Defo
DAS		:	Location	Loc Oty		Loc Code	•	
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9-0-0		,	122800	2				
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AN960JD416 Washer	NAS1149D0463J Purchased	No		110	Each	29.0000	126 23	
DAS			Location	Loc Qty		Loc Code		***
27			ST351	29				
9-69			116289	8				
			119097	21				_
AN960JD416L	NAS1149D0416J Purchased	No		110	Each	6.0000	6) Mr
Washer							V 125773	3.3
DAS 27			Location	Loc Qty		Loc Code		es 🔨
9- 8 9			FP002	6				
~ ~~			110153	6				_
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BARBED ELBOW	Turchased						V	33
27			<u>Location</u>	Loc Oty		Loc Code	f	6 6
9-89			ST281			Tion Code		
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9-89			<u>Location</u>	Loc Qty		Loc Code	•	
			ST093	1				•
			64619	1			7	9 -•
MS20392:3C21	Purchased	No		110	Each	15.0000	12429	33 13-09-06
Pin 27								
)-89		,	Location .	Loc Qty		Loc Code		
			ST316	15				
			104156	15				
								•

											DQA:	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFOR	MANCE / UPDATE					
						 · · · · · · · · · · · · · · · · · · ·					QA Closed:	Date	e:	
Work Ord	er:					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		1
						Rework	1		Skid-tube Crosstube			Water Jet	<u>֓</u> ֡֓֞֝֞֜֝֡֡֡֡	Engineering
Part	۷o.					Scrap	1		Machining Small Fab	—	Pro	d. Eng. Coor.		Quality
				-	<u>-</u>	Use-as-is		Thern	noforming Finishing			re/Packaging		Other
NCR	No.					Work Order Update			Large Fab Composite			Supplier		
						 					·	ً .ون	~~ ~~	
Root		_		_	Des	ption of work order update		nitial	Action	•	Sign &		ه مرم	
Cause		Date	Step	Qty	<u> </u>	 or Non-conformance	Ch	ief Eng	Description		Date	Verification	-+	QC Inspector
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upplier	\vdash													
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napproved			•											
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Landi	ng (Gear				General					_	_		
		Bending				Bend ,		Grain			Ovalized		P	Pressure/Forced
		Centre No	ot Concer	ntric to	o/s .	BOM/Route		Hardwa	re		Over/Under	tolerance	┛	emperature/Cure
		Cracks				Broken/Damaged		Inspect	on Incomplete		Part Incorre	ct	_	Weld
	L	Crushed/0	Crimped,			 Burrs		Instruct	ions Incomplete/Unclear	┕	Part Lost/Mi	issing	\v	Wrong Stock Pulled
		Cuffs				Contamination		Mainte		<u> </u>	Part Moved			
	_	Heat Trea				 Countersink		Mislabe		\vdash	Positioned V		\neg	
	<u> </u>	Inspection	•	Tube		Cut Too Short		Misread	i		Power Loss/	Surge		Other
•	L	Ripples in				 Drill Holes	<u> </u>	Offset				·		· · · · · · · · · · · · · · · · · · ·
	_	Torque W		xtrusio	n	Drawing	<u> </u>	l	Calibration					
		Turning Se	equence			Finish		Out of 9	Sequence					

Outside Dimensions

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Wave/Twist in Tube

Folio

November-27-12 11:25:14 AM

Work Order ID:

93803

Parent Item:

MS2104214 Nut

Parent Item

n:	41232-000-001-002		•					Start	Date: 11/22/12	Required Date: 12/14/12
n Name:	Emergency Flotation	Step Actuator, RH						Star	rt Qty: 1.00	Required Qty: 1.00
		Purchased	No			110	Each	4,205.0000	126333	33
				<u>Location</u>		Loc Oty		Loc Code	•	
				314		18	4			
DAS				1	22452	18	4			
27				Return2012	2		8			
9-89				1	23021		8			
				ST300		2	O			
				1	19017	2	0		***************************************	1
				ST314		399	3			
					23021	149	3			
					23248	90			A	
53 1				1	23355	160				0.4
Ω D/ 2	4S 7	Purchased	No			110	Each	223.0000	125646	33
	89			Location		Loc Qty		Loc Code		
				ST323		22	3			,
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				i	7566	7	4		a)	
}		Purchased	No			110	Each	60,0000	124903	330 13-09-06
				Location		Loc Oty		Loc Code		
DAS				ST295		3	2			
27					20769		1			
9-89				1	21708	3	1			

28

ST296

116235

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	- -	

									QA Closed:	Date): 		
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Descri	ption of work order update	Initial	Act	tion	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator													
Material													
Setup													
Other		ļ											
Process											. ~		
Supplier													
Training											- ₫		
Unapproved													
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Landir	ng Gear				General				-	_	_		
	Bending				Bend	Grain			Ovalized	_	Pressure/Forced		
	Centre No	ot Concer	ntric to C	D/S	BOM/Route	Hardw	are		Over/Under tolerance		Temperature/Cure		
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld		
	Crushed/Crimped.				Burrs	\blacksquare	tions Incomplete/l	Unclear	Part Lost/M	- L	Wrong Stock Pulled		
	Cuffs			ļ	Contamination		enance		Part Moved				
	Heat Treat			<u> </u>	Countersink	Mislab			Positioned Wrong				
	Inspection	•	Tube		Cut Too Short	Misrea		<u> </u>	Power Loss/	'Surge	Other		
	Ripples in				Drill Holes	Offset					, *		
-	Torque W		xtrusion	· _	Drawing	\vdash	Calibration			_			
1	Turning S	•		<u> </u>	Finish	\vdash	Sequence						
1	Wave/Twist in Tube				Folio	Outside Dimensions							

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November-27-12 11:25:14 AM

Work Order ID:

93803

Parent Item:

R-3400

DAS

27

9-89

41232-000-001-002

Parent Item Name:

Emergency Flotation Step Actuator, RH

Purchased

No

110

34.8000

Loc Code

Start Date: 11/22/12

Required Date: 12/14/12

Start Qty: 1.00

Required Qty: 1.00

- The Real Property (1997)

3.05

plastic tubing 1/4id x 3/8od-black (5255K19)

Smb

 Location
 Loc Oty

 st376
 21.95

 123366
 21.95

 ST389
 12.85

 109886
 12.85

123366

8

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

									QA Closed:	Date	B:		
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update] The	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Descri	ption of work order update	Initia	A	ction	Sign &				
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng Dese	cription	Date	Verification	QC Inspector		
Doc/Data					·- ·	ĺ							
Equip/Tooling			1										
Operator						}							
Material							ļ						
Setup									1				
Other						1							
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					F	AULT CA	TEGORY						
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L	Bending			<u> </u>	Bend	Grai		_	Ovalized		Pressure/Forced		
	Centre No	ot Concer	ntric to O	/s	BOM/Route	Hard		_	Over/Under		Temperature/Cure		
<u> </u>	Cracks				Broken/Damaged	_	ction Incomplete	<u> </u>	Part Incorre	⊢	Weld		
Ĺ	Crushed/	Crimped.			Burrs	-	uctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
	Cuffs				Contamination	Maii	ntenance		Part Moved				
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	Inspection	n Strip in	Tube		Cut Too Short	Misr			Power Loss/	'Surge (Other		
	Ripples in			$oxedsymbol{oldsymbol{oldsymbol{oldsymbol{eta}}}$	Drill Holes	Offse					الميان		
	Torque W	aves in E	xtrusion	<u> </u>	Drawing	\vdash	of Calibration			-·			
L	Turning S	equence			Finish	Out	of Sequence						
1	Wave/Twist in Tube				Folio	Outs	ide Dimensions						

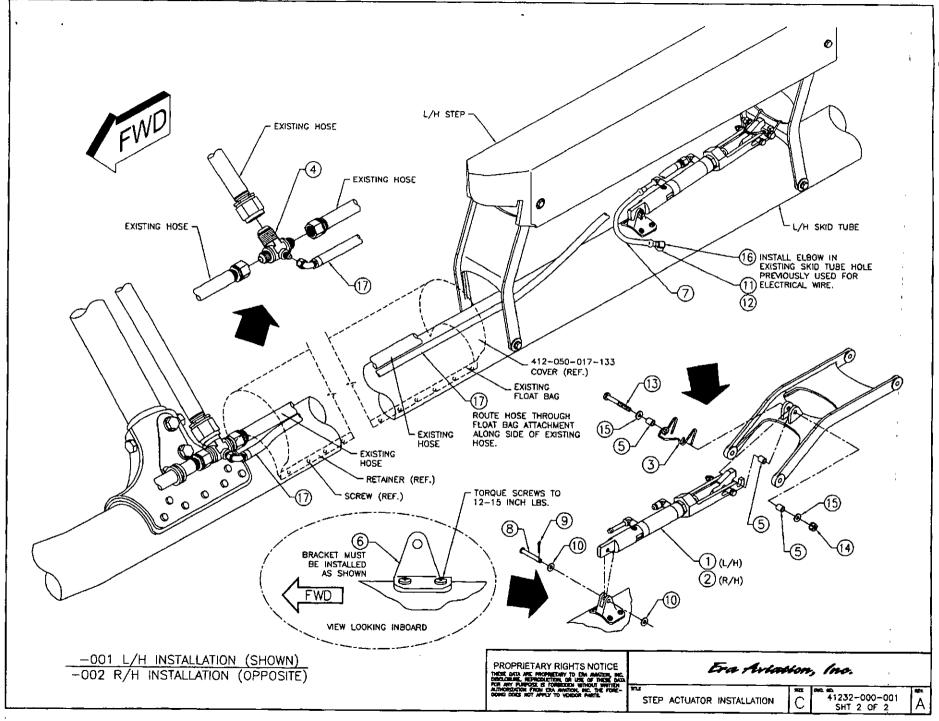
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	REVISION									
LETTER	DITISMAN	DATE	DESCRIPTION	APPROMED	DATE					
A	DNN	1/14/04	INCORP. E.O.; CHG. P/N OF ITEM #17.	tjs04-1-1	1/14/04					
			MINOR CHANGE - FAR 21.95							

93803 MUT

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			2	2	10	AN960JD416L	WA	SHER]		1				_
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			2	2	7	R-3400 1/4 ID x 3/8 00 BLACK	PL	ASTIC TUE	BING	NORTON I	PERFORM	ANCE	PLASTIC	S COR	P., AKRON, OH	IO 443
	1 1 6 41232-200-006-001		BRACKET		(ALT. P/	N 412-	-050-	026-1	01, B	ELL HELICOPT	ĖR)					
			3	3	5	41232-200-005-001	SP.	ACER						Т		
		_	1	1	4	41232-200-004-001	REI	DUCER TE	E							
			1	1	3	41232-200-003-001	SP	RING								
			1		2	41232-200-001-002	R/I	H ACTUATO	R ASSY							1
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